

Date: Monday, 2/19/2007 8:59:46 AM
 User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : WEARSHOE
Job Number : 30760	
Estimate Number : 12740	
P.O. Number : N/A	Part Number : D353523
This Issue : 2/19/2007 S.O. No. : N/A	Drawing Number : D3535 UNDER REVIEW REV A PH 070219
Prsht Rev. : NC	Project Number : N/A
First Issue : N/A	Drawing Revision : U/R
Previous Run : N/A	Material : N/A
Written By : <u>[Signature]</u>	Due Date : 2/26/2007
Checked & Approved By : <u>[Signature]</u> 07.02.19	Qty: 13 / 12 Um: Each
Comment : Est Rev: A New Issue 07-02-15 JLM	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
---------	-----------------------	---------------

1.0	M304S20GA	304/316 .040 Sheet
-----	-----------	--------------------



Comment: Qty.: 1.4296 sf(s)/Unit Total : 17.1549 sf(s)

304/316 .040 Sheet

(M304S20GA)

Batch: M101873

SAD

07/02/25

2.0	WATER JET	FLOW WATER JET
-----	-----------	----------------



Comment: FLOW WATER JET

1-Cut as per Dwg D3535

Dwg Rev: A

Prog Rev: A

SAD 07/02/25

2-Deburr if necessary

E

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
-----	-----	--



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

SAD

07/02/25

4.0	QC8	SECOND CHECK
-----	-----	--------------



Comment: SECOND CHECK

E

070225

13

5.0	BRAKE NC	NC BRAKE
-----	----------	----------



Comment: NC BRAKE

1-Form on Brake as per Dwg D3535 using Jigs DT8261 and DT8326

2-Form joggle as per Dwg D3535 using Jig DT8158

3-Identify as D3535-23

MF. SB

07-03-05

07/03/06 13

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: LD Date: 07/03/08
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Monday, 2/19/2007 8:59:46 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: WEARSHOE

Job Number: 30760

Part Number: D353523

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

07/03/07 (13)

7.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat Grey Sandtex (Ref: 4.3.5.6) as per QSI 005 4.3

M101601

07-03-07 (13)

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

a.m

07/03/07

(13)

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock
Location: EL

MS

07-03-08

(13)

10.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

07/03/08

Job Completion



07-03-08

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

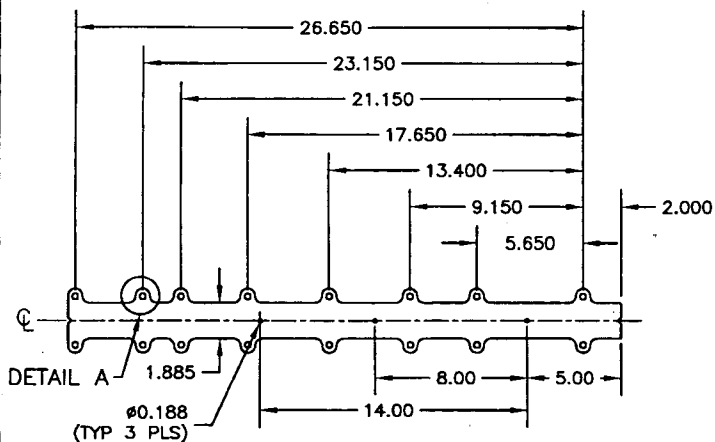
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

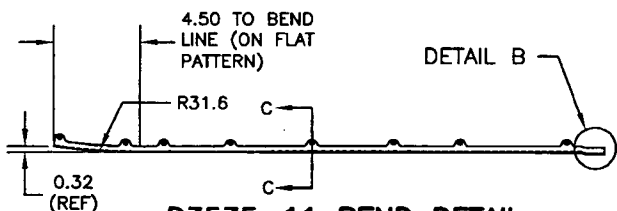
DART

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07.02.12

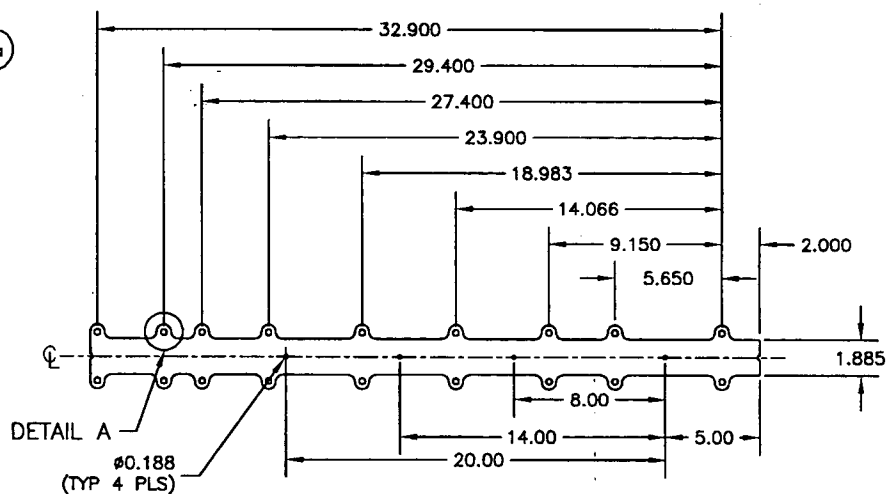
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CB	CB	PORT HADLOCK, WA
CHECKED	APPROVED	DRAWING NO.
PH	PH	D3535
DATE	TITLE	SHEET 1 OF 7
06.10.25	WEARSHOE	SCALE 1:10
A	06.10.25	NEW ISSUE



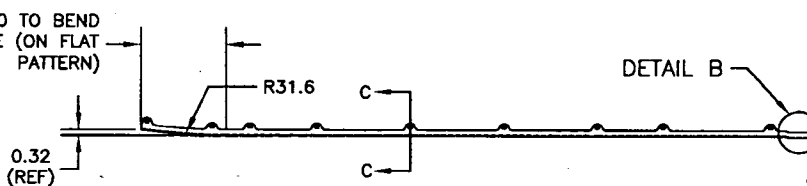
D3535-11F FLAT PATTERN



D3535-11 BEND DETAIL



D3535-13F FLAT PATTERN



D3535-13 BEND DETAIL

NOTES

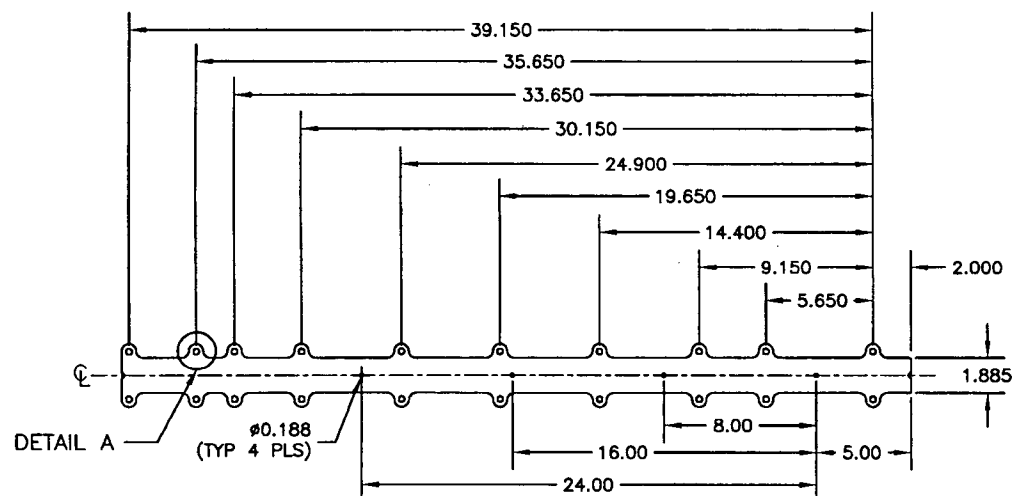
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- 2) FINISH: POWDER COAT GREY SANDEX (4.3.5.6) PER QSI 005 4.3
- 3) PART IS SYMMETRICAL ABOUT ϕ
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) BREAK ALL SHARP EDGES TO 0.010 MAX
- 7) IDENTIFY WITH DART P/N USING WHITE FINE POINT PAINT MARKER
- 8) SEE PAGE 7 FOR DETAILS AND SECTION

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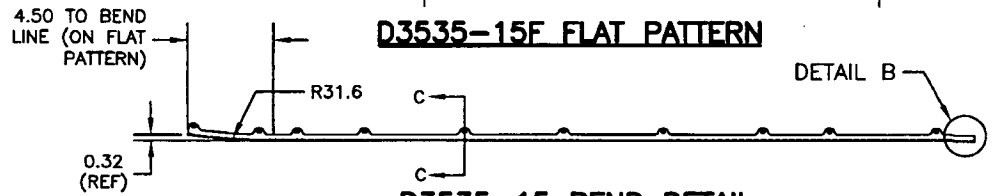
DART

DESIGN	C.B.	DRAWN BY	C.B.	DART AEROSPACE USA, INC.
CHECKED	H.H.	APPROVED	H.H.	PORT HADLOCK, WA
DATE	06.10.25	TITLE	D3535	WEARSHOE
		REV. A	SHEET 2 OF 7	SCALE 1:10

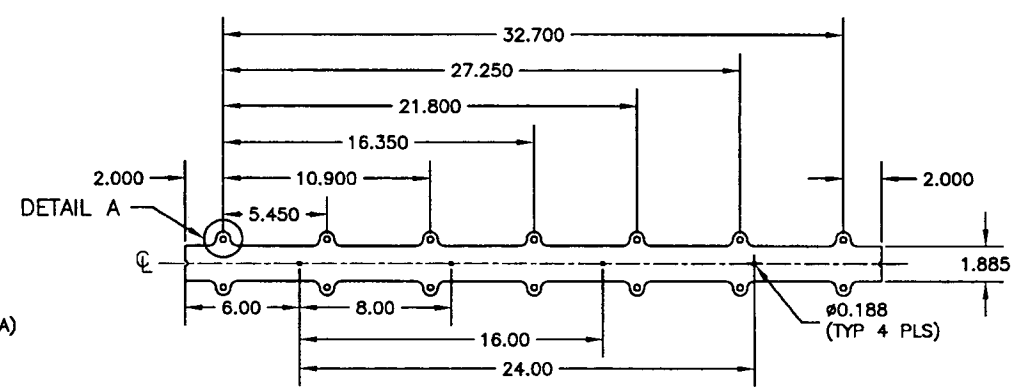
07.02.12
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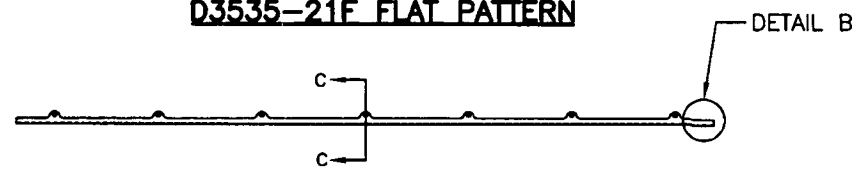
D3535-15F FLAT PATTERN



D3535-15 BEND DETAIL



D3535-21F FLAT PATTERN



D3535-21 BEND DETAIL

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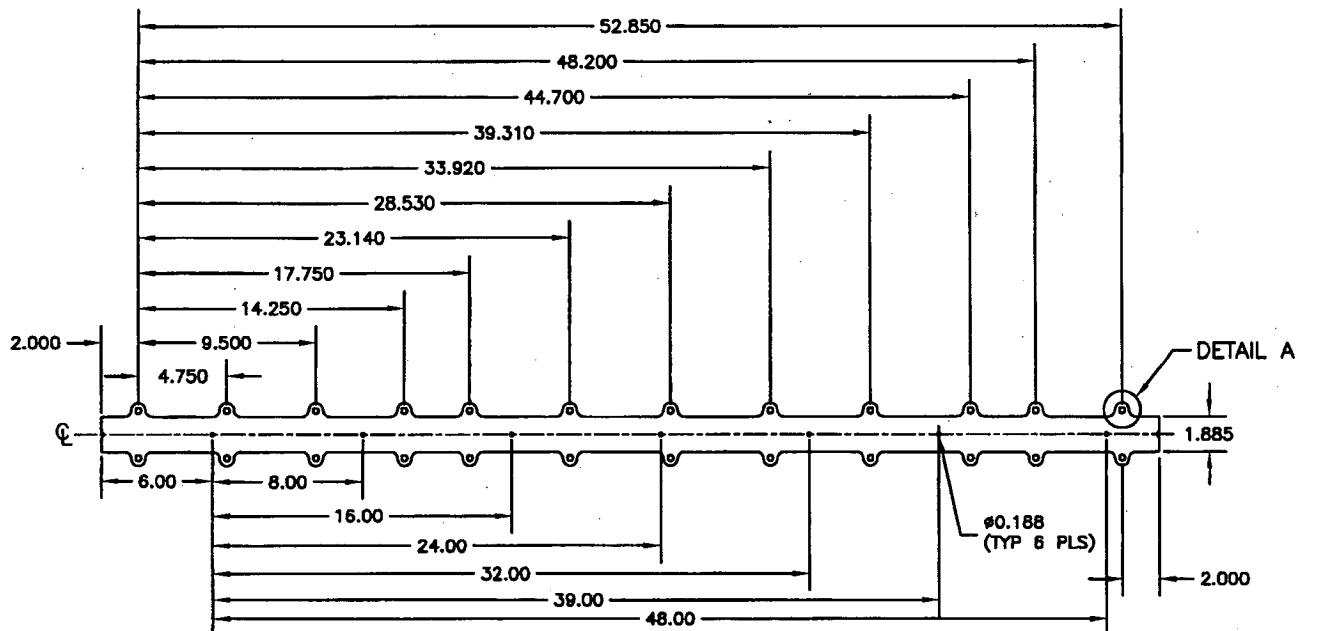
NOTES

- 1) MATERIAL: AISI 304/316 SS SHEET, 20 GAUGE (0.038 THICK, REF DART SPEC M304S20GA)
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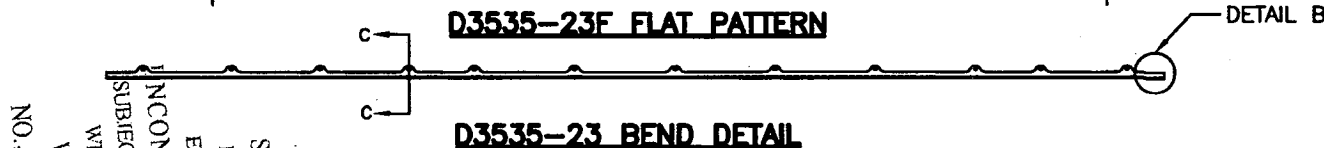
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DESIGN CB	DRAWN BY CB	DART AEROSPACE USA, INC. PORT HADLOCK, WA
CHECKED AM	APPROVED AM	DRAWING NO. D3535
DATE 06.10.25	TITLE WEARSHOE	REV. A SHEET 3 OF 7
	SCALE 1:10	

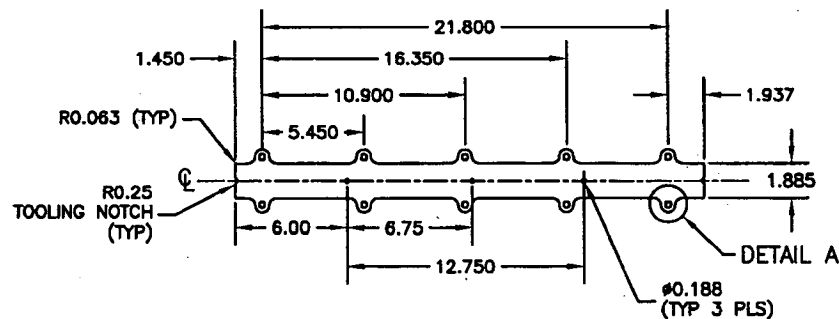
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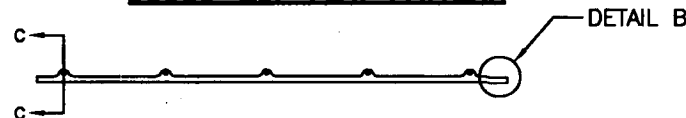
D3535-23F FLAT PATTERN



D3535-23 BEND DETAIL



D3535-25F FLAT PATTERN



D3535-25 BEND DETAIL

NOTES

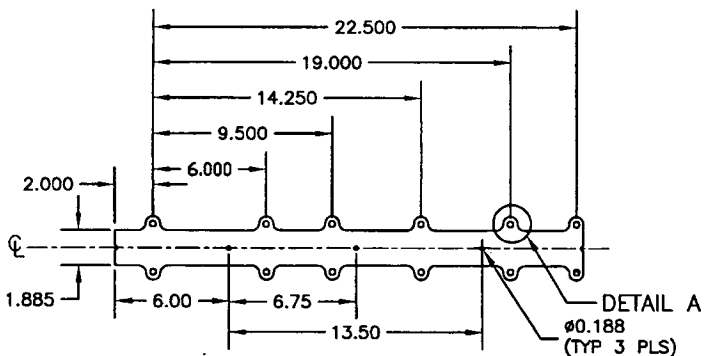
- 1) MATERIAL: AISI 304/316 SS SHEET, 20 GAUGE (0.038 THICK, REF DART SPEC M304S20GA)
- 2) FINISH: POWDER COAT GREY SANDTEX (4.3.5.6) PER QSI 005 4.3
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DESIGN	C.B.	DRAWN BY	C.B.	DART AEROSPACE USA, INC.	REV. A
CHECKED	PH	APPROVED	PH	PORT HADLOCK, WA	SHEET 4 OF 7
DATE	06.10.25	TITLE	WEARSHOE	SCALE	1:10

07.02.12 CH



D3535-31F FLAT PATTERN

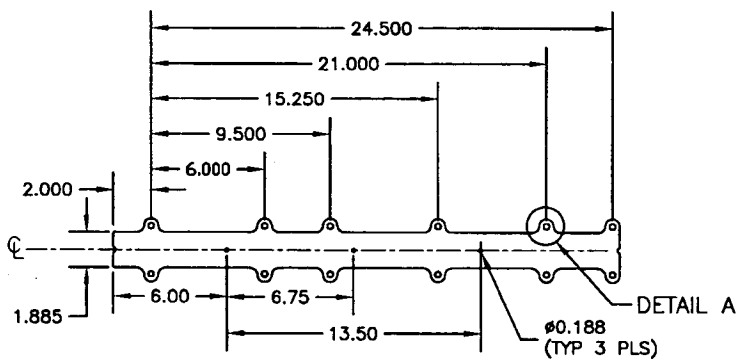


D3535-31 BEND DETAIL

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D3535-33F FLAT PATTERN

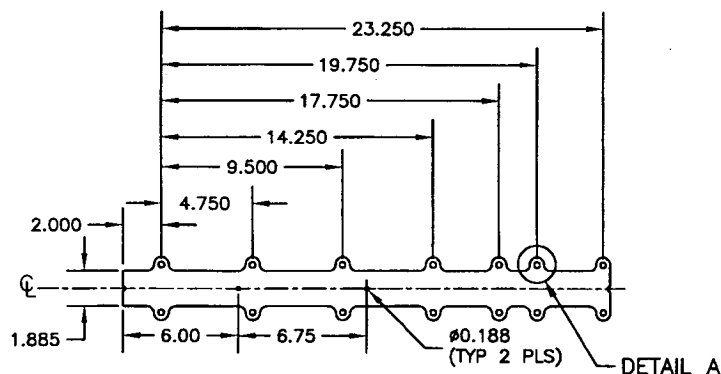


D3535-33 BEND DETAIL

DART

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CHECKED <i>PH</i>	APPROVED <i>PH</i>	DRAWING NO. D3535	REV. A
DATE 06.10.25	TITLE WEARSHOE	SHEET 5 OF 7	SCALE 1:10

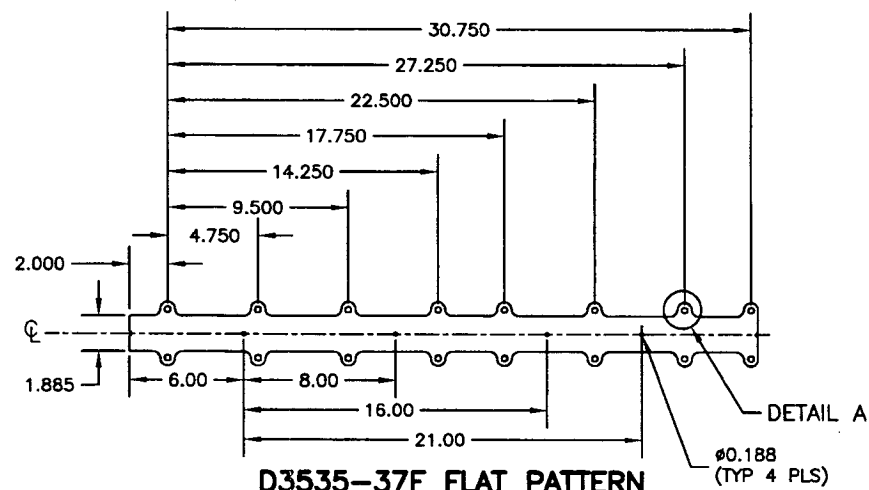
67022 CH

**D3535-35F FLAT PATTERN****D3535-35 BEND DETAIL**

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NOTES

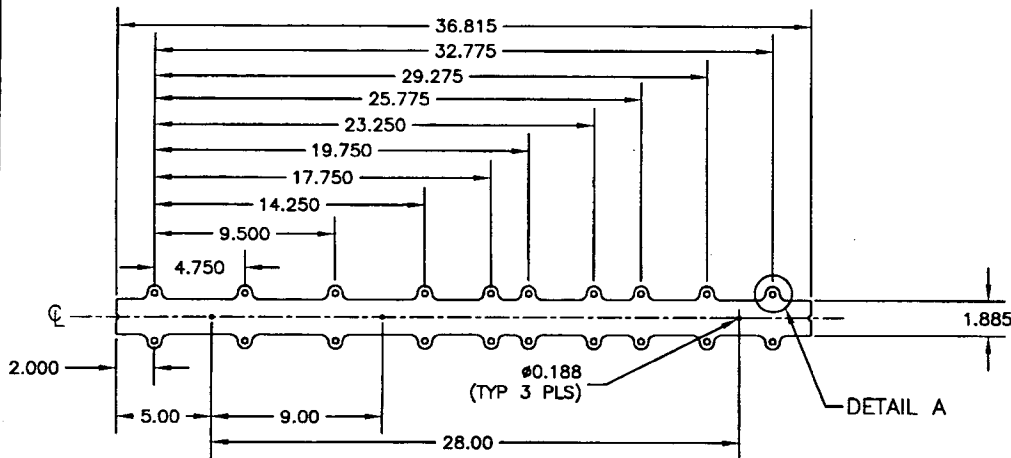
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**D3535-37F FLAT PATTERN****D3535-37 BEND DETAIL**

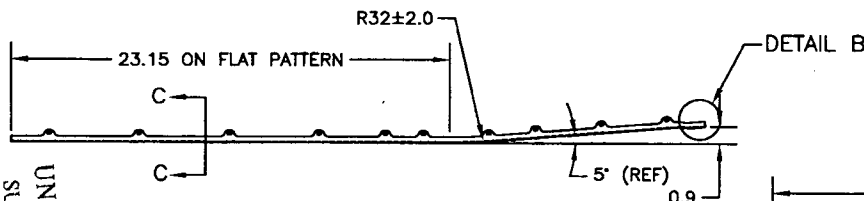
DART

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CHECKED AF	APPROVED AF	DRAWING NO. D3535
DATE 06.10.25	TITLE WEARSHOE	SHEET 6 OF 7
	SCALE 1:10	REV. A

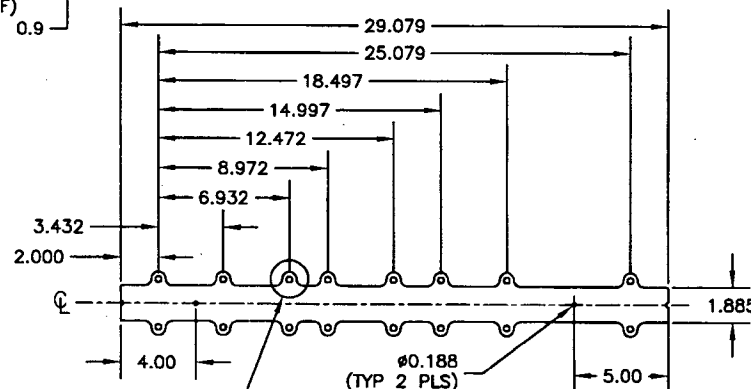
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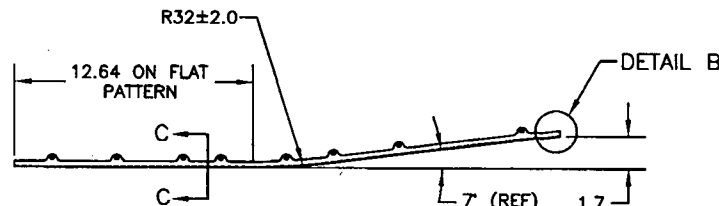
D3535-39F FLAT PATTERN



D3535-39 BEND DETAIL



D3535-41F FLAT PATTERN



D3535-41 BEND DETAIL

NOTES

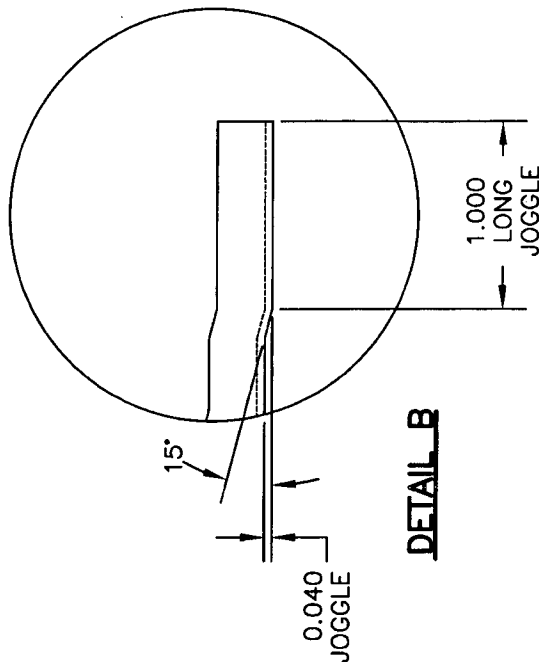
- 1) MATERIAL: AISI 304/316 SS SHEET, 20 GAUGE (0.038 THICK, REF DART SPEC M304S20GA)
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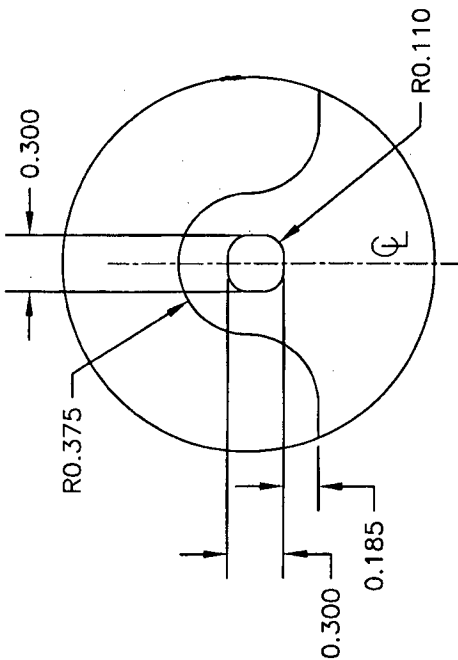


DESIGN CB	DRAWN BY CB	DART AEROSPACE USA, INC. PORT HADLOCK, WA	
CHECKED <i>PH</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3535	REV. A SHEET 7 OF 7
DATE 06.10.25		TITLE WEARSHOE	SCALE 1:1

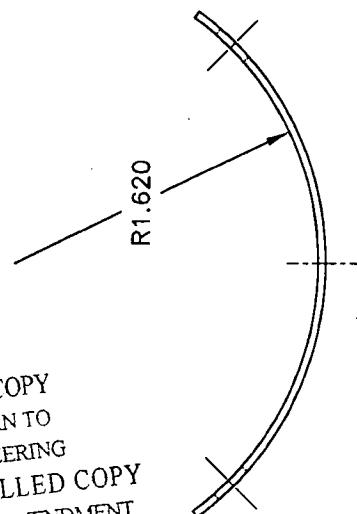
RELEASED
07.02.12 *[Signature]*



DETAIL B



DETAIL A



SECTION C-C

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DART AEROSPACE LTD		Work Order: 30760
Description:		Part Number: D3535 25
Inspection Dwg:	Rev:	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☒ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
52.850	± 0.000	52.850	✓		M-T	
48.200	± 0.010	48.200	✓		M-T/Vern	
44.700	± 0.010	44.700	✓		M-T	
39.300	± 0.010	39.300	✓		M-T	
33.920	± 0.010	33.920	✓		M-T/Vern	
28.530	± 0.010	28.525	✓		M-T/Vern	
23.140	± 0.010	23.140	✓		M-T Vern	
17.750	± 0.010	17.750	✓		M-T/Vern	
14.250	± 0.010	14.250	✓		M-T	
9.500	± 0.010	9.504	✓		Vern	
4.750	± 0.010	4.753	✓		Vern	
2.000	± 0.010	2.000	✓		Vern	
6.00	± 0.030	6.00	✓		Vern	
8.00	± 0.030	8.00	✓		Vern	
16.00	± 0.030	15.99	✓		Vern	
24.00	± 0.030	24.00	✓		M-T	
32.00	± 0.030	32.00	✓		M-T	
39.00	± 0.030	39.00	✓		M-T	
48.00	± 0.030	48.00	✓		M-T	
2.000	± 0.010	2.000	✓		Vern	
1.885	± 0.010	1.889	✓		Vern	
0.300	± 0.010	0.292	✓		Vern	
0.300	± 0.010	0.297	✓		Vern	

Measured by: SAN	Audited by: BG	Prototype Approval:
Date: 07/02/25	Date: 07.02.25	Date:

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	

